

Date: Friday, 11/16/2007 7:21:14 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BATTERY LOCK CASHING
Job Number : 35808	
Estimate Number : 10474	
P.O. Number :	Part Number : D33931
This Issue : 11/16/2007 S.O. No. :	Drawing Number : D3393 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 23552	Material :
Written By : <u>Jim 11/16</u>	Due Date : 12/10/2007 Qty: 10 Um: Each
Checked & Approved By : <u>Jim 11/16</u>	
Comment : Est. A 05.02.18 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
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Comment: Qty.: 0.2843 f(s)/Unit Total : 2.8434 f(s)
6061-T6 Bar 1.5" x 1.5"
Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
(M6061T6B1.500x01.500) Batch: M102723

JP 02/11/20 (10)

2.0	BAND SAW	BAND SAW
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Comment: ~~BAND SAW~~ HAAS #1 JP 07-12-18
Cut blank: 1.500" x 1.500" x 3.125" long
Machine D3393-1 as per Folio FA510 and Dwg D3393
Identify as D3393-1
Deburr

JP 07/11/20 (10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 07/12/14 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JP 07-12-14 (10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

JP 07-12-12 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:21:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK CASHING

Job Number: 35808

Part Number: D33931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M/8052



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FD 07/12/12 (10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/ 07/12/18 (10X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57486

AS 07/12/18

(X10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2007/12/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35808
Description: Battery Lock Casing		Part Number:	D3393-1
Inspection Dwg: D3393	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010 ^{+0.010} _{-0.000}	Ø0.750	—			
0.625	+/-0.010 ^{+0.010} _{-0.000}	0.625	—			
Ø1.250	+/-0.010 ^{+0.010} _{-0.000}	Ø1.252	—			
1.088	+/-0.010	1.086	—			
Ø0.734	+/-0.010 ^{+0.010} _{-0.000}	Ø0.736	—			
2.658	+/-0.010	2.658	—			
1.550	+/-0.010	1.549	—			
0.125 x 45°	+/-0.010	0.117 x 45°	—			
1.50	+/-0.030	1.490	—			
0.750	+/-0.010	0.743	—			
Ø1.050	+/-0.010	Ø1.060	—			
Ø1.000	+/-0.010	Ø1.000	—			
0.338	+/-0.010	0.336	—			
0.563	+/-0.010	0.573	—			
0.100	+0.000/-0.010	0.097	—			
3.00	+/-0.030	3.003	—			
1.500	+/-0.010	1.500	—			
0.375	+/-0.010	0.371	—			
1.25	+/-0.030	1.245	—			
0.125	+/-0.010	0.125°	—			
30°	0.5°	30°	—			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07/12/13	Date: 07.12.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



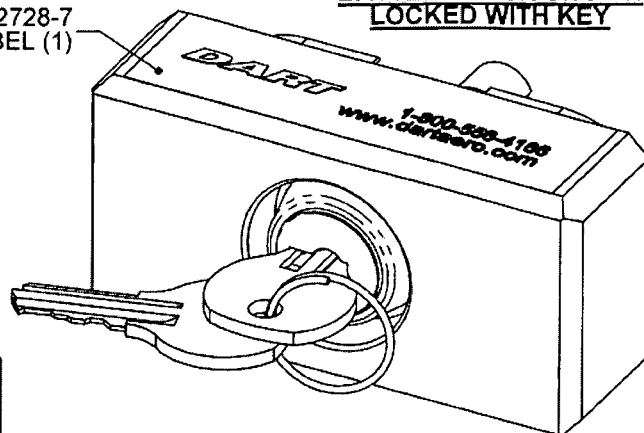
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

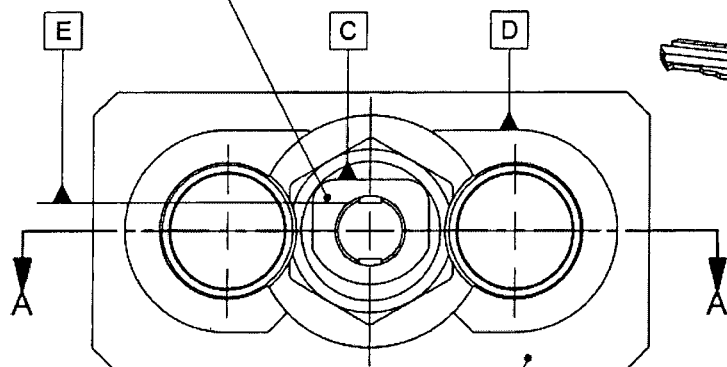
05/03/09

D2728-7
LABEL (1)

BATTERY LOCK SHOWN
LOCKED WITH KEY



POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2)
AND APPLY KRAZY GLUE

0.09^{+0.03}
-0.01 (2 PLACES)

D3393-3 CAM
LOCK SHAFT (1)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

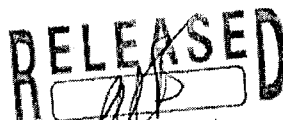
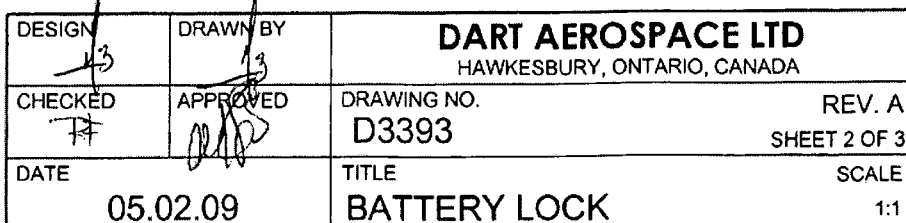
NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: MCMASTER-CARR, P/N 9567K21

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NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

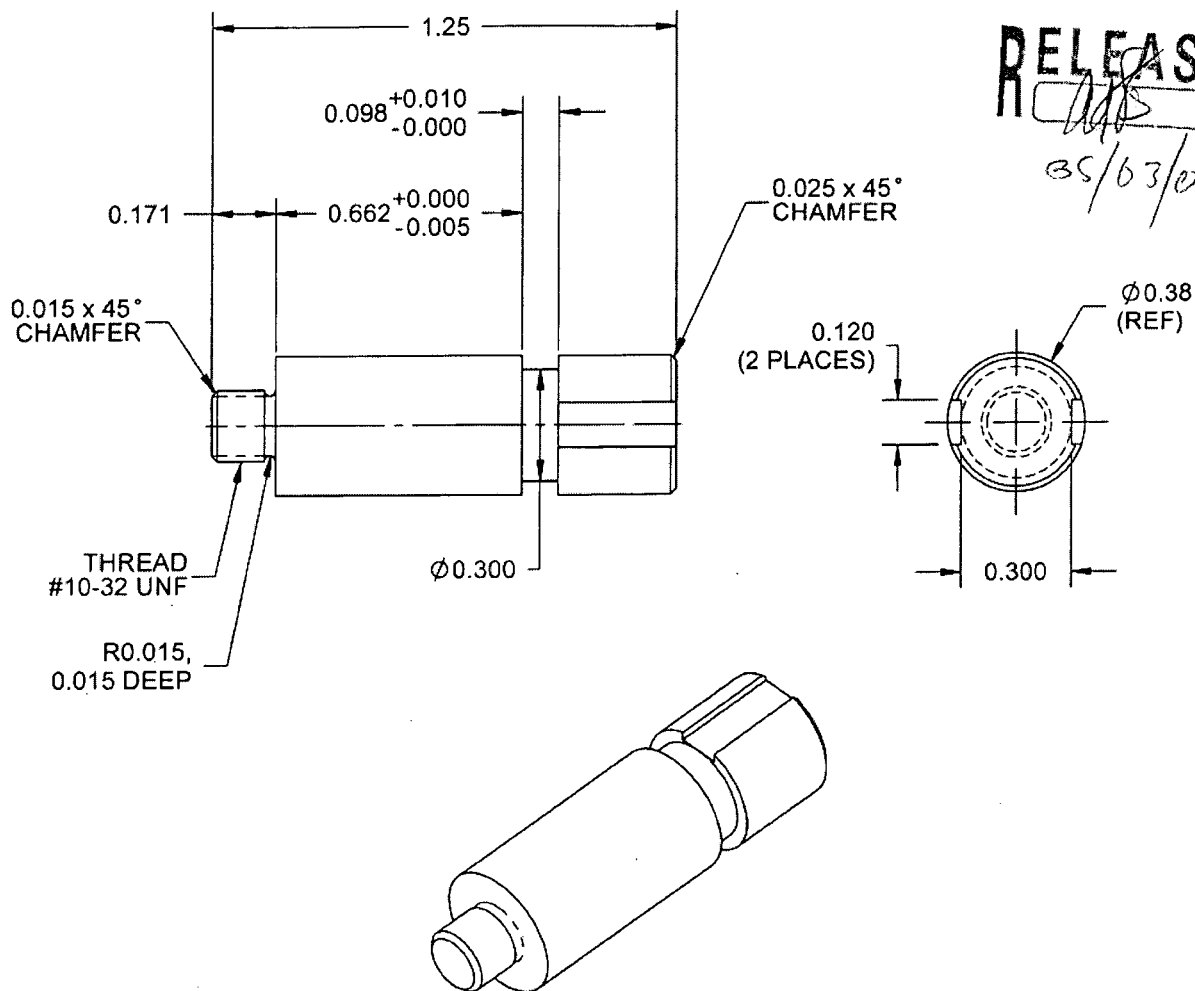
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



RELEASED
[Signature]
05/03/09

D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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